

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024073**Date Inspected:** 26-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Shi Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

OBG Trail Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SA3127-005~010-010, 012 located on side plate connected SA3127 at panel point 124 to 124.5 FL1 side of OBG Segment 13CW. ZPMC Welder is identified as 045240 ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2131-ESAB.

FCAW welding of weld joint SA3126-003~005-006, 008 located on bottom plate connected SA3126 at panel point 123 to 123.5 FL1 side of OBG Segment 13CW. ZPMC Welder is identified as 045143. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2131-ESAB.

FCAW welding of weld joint SA3122-005~008-007 and 010 located on bottom plate connected SA3122 at panel point 121 to 121.5 FL2 side of OBG Segment 13BW. ZPMC Welder is identified as 066825. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

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Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3014N-051, 056, 061, 066 and 071 located on Side plate RS Stiffener to Floor Beam at panel point 121.5 of OBG Segment 13BW. ZPMC Welder is identified as 040270. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPSB-P-2214-B-U2-FCM-1.

SMAW welding of weld joint SEG3014L-058, 062, 064, 068, 070, 074, 076 and 080 located on side plate RS Stiffener to Floor Beam at panel point 121 of OBG Segment 13BW. ZPMC Welder is identified as 066687. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2114-FCM-1.

SMAW welding of weld joint OBW13B-003 located on bottom plate to bottom plate of OBG Segment 13A+BW. ZPMC Welders are identified as 037748 and 066359. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-1G-(1F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21048.

This QA inspector observed ABF personnel performed Ultrasonic Testing (UT) on deck panel to deck panel splice weld of OBG Segment 13AW and 13BW. The weld number is identified as OBW13-001.

ZPMC personnel performing heat straightening on longitudinal diaphragm at panel point 122 to 122.5 of OBG Segment 13B/CW. Distortion appeared to be caused by mishandling of the welding/material. ZPMC Quality Control (QC) inspector identified as Mr. Sun Tian Liang was present to monitor the heat straightening process. The heat straightening appeared to comply with HSR1 (B) number 10383.

Visual Inspection after Blast – Trail Assembly Yard

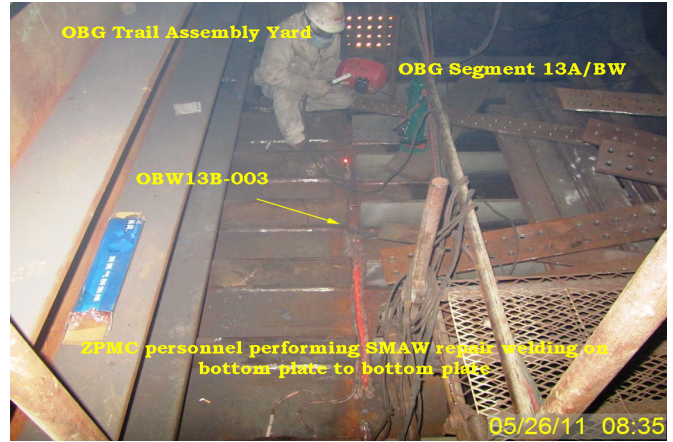
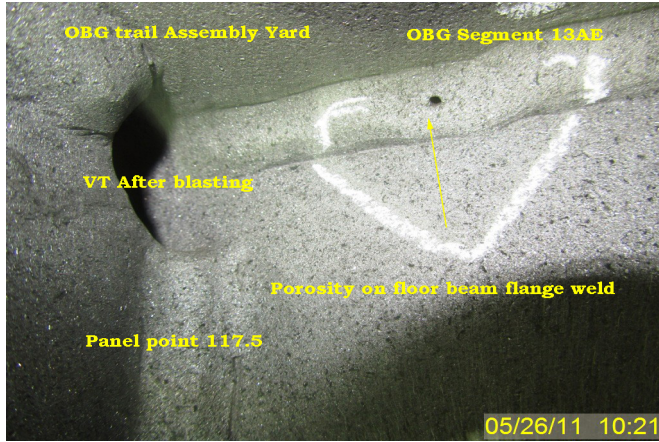
OBG Segment 13AE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 13AE, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. The panel point is identified as PP117.5 to 118 at counter weight side of OBG Segment 13AE. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. See the attached picture.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer